	er ID 119562 2014 1:14:18 PM	0.3 5	531-3	*11	9562*							Page 1
Item ID: Revision ID:	D3531-3	8 1	19562	Accept	*N900	1040	10	N *	Setup		*N	S1*
Item Name: Start;Date: Required Date: Reference:		t Qty: 10.00 d Qty: 10.00	*10 *10		Cust Item Customer			·		Stop	*N.	S2*
Approvals:	Process Plan:	MLJ	Date: /Y-05-	ZZTooling:		Date:				Start	*N	R1*
	QC:		Date:	SPC (Y/N):	1	Date:				Stop		R2*
Sequence ID/ Work Center II	Oper Descr	ation iption		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reje Qty		Reject Number	Insp. Stamp
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110	QC2- I	nspect parts off ma	chine FAI/FAIB	0.00								
110 QC Quality Control		Мето		0.00			(10		- -	mm	17/07/15
¹²⁰ *12∩ *	QC8- I	nspect parts - secoi	nd check	0.00 \$-	7			10				
QC		Mama		000 141	1117			10				

Quality Control

DQA:			Date:										TRAGE	7
						WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE			. –	AEROSPACE	<u>.</u>
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	or.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIG	٠,		•			Rework			Skid-tube Crosstube]	Water Jet	Engineering	
Part N	No.					Scrap	ı		Machining Small Fak		Pro	d. Eng. Coor.	Quality	
	•					Use-as-is			moforming Finishing	,	Rec/Stor	re/Packaging	Other	
NCR I	۱o. ِ	<u></u>				Suspected Unapproved			Large Fab Composite			Supplier		
Root					Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
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	H	Centre No	nt Concer	ntric		BOM/Route		Grain			Over/Under	<u> </u>	Set-up	
		Cracks			-	Broken/Damage/Defect		Hardwa	are		Part Incorred	 	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		1	tion Incomplete/Unqualified		Part Lost/Mi	issing	Weld	
	-	Cuffs				Contamination		ł '	tions Incomplete/Unclear	Г	Part Moved		Wrong Stock Pulled	
	-	Crushing				Countersink	Г	4	gned/off center		Positioned V	Vrong		
		Heat Trea				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other	
	Inspection Strip in Tube Drawing			Misread										
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
	Turning Sequence Finish Wave/Twist in Tube Fit/Function					Out of Sequence								

Work Ord Friday, May 16					*110	956	32*	-						Page	2
Item ID: Revision ID: Item Name:	D3531-3 Bracket Front	Plate		F	Accept	*	1 900	040	110	N *	Setup	Start Stop	· I U	S1*	
Start Date: Required Date: Reference:	5/15/14 5/15/14	Start Qty: 10.00 Req'd Qty: 10.00	_	0* 0*			Cust Item I Customer:	D:				-	"IV	S2*	
Approvals:		nn:	Date:		Tooling: SPC (Y/N):			nte:			Run	Start Stop	^IVI	R1*	
Sequence ID/ Work Center II 140 *140* Brake NC Brake NC)	Operation Description Bend as per dwg NC BRAKE Memo			Set Up/ Run Hours 0.00		Tool ID	Tool # DAS 30 9-89	Code	Accep Qty	Qty		*N Reject Number	R2* Insp. Stamp	yla
150 *150* QC Quality Control		QC5- Inspect part comple Memo	teness to step on V	W/O	0.00 DAS 27 9-89 0.00 H	1/16				<u>K</u>					_

160

Hand Finishing

Chemical Conversion Coat per QSI005 4.1 *160*
HandFinish 0.00 Memo

DQA:			Date:	Date: WORK ORDER NON-CONFORMANCE / UPDATE							TRACT		
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPD				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	·
Work Orde						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
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Part N	lo.					Scrap		1	─	Small Fab	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is			~ 	Finishing	-1	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Co	omposite		Supplier	
Root					Descr	ription of work order update		nitial	Action		Sign &		
Cause	\dashv	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	QC Inspector
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	_	Bending			_	Bend	<u> </u>	1	Program		Outside Dim		Pressure/Forced
	\vdash	Centre Not Concentric BOM/Route		•	<u> </u>	Grain		<u> </u>	Over/Under	 	Set-up		
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	\vdash	Crimp/Kink/Ripple/Wave Burrs		<u> </u>	4 '	ion Incomplete/Unqua	_	Part Lost/Mi	ssing	Weld			
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	Crushing Countersink		<u> </u>	1	gned/off center	-	Positioned V		Jothan				
	Heat Treat Cut Too Short Inspection Strip in Tube Drawing			Mislabeled				Power Loss/Surge Other					
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Work Ord Friday, May 16,				*119562*										
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3531-3 Bracket From 5/15/14 5/15/14	nt Plate Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*	Accept	*N90 Cust Iter Custome	n ID:	110	ገ*	Setup	Start Stop	1.71	S1* S2*		
Approvals:	Process P. QC:	lan:	Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop	*N	R1* R2*		
Sequence ID/ Work Center II 170 *170* QC Quality Control)	Operation Description QC7-Inspect Chemical Co	onversion Coat	Set Up/ Run Houses 0.00 27 9-89 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp		
*180 *180* Packaging Packaging		Identify as per dwg & Stor	ck Location:	0.00				10)X_	-	/R	/-7-18		
190 *1 Q ^*		QC21- Final Inspection - \footnote{V}	Work Order Release	0.00				ML	5 '	\Y-V	7-21			

0.00

Memo

Quality Control

DQA:			Date:				DER NON-CONFORMANCE / UPDATE						TRAC [*]		
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QA Closed:			Date:				_				VVC	nk Order up	date only		
Work Orde	er:				1	DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
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Part N	lo.					Scrap			Machining	Small Fab	┪	Pro	d. Eng. Coor.	┪	Quality
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	\vdash	Cracks			-	Broken/Damage/Defect	┝	Hardwa	-		_	Part Incorred	-	-	Weld
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	-	Cuffs				Countamination	_	_1	tions Incomplete/l	unciear	-	Part Moved	Vrong		Wrong Stock Pulled
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	Inspection Strip in Tube Drawing			-	Misrea Off-set						-				
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	\vdash	Turning S	•		⊢	Finish Fit /Function	-	4							
	Wave/Twist in Tube Fit/Function					Trick current	Out of Sequence								

Page 1

Work Order ID: 119562

119562

Parent Item:

D3531-3

D3531-3

Parent Item Name: Bracket Front Plate

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 10.00

2.1

Required Oty: 10.00

mm 14/07/15

Comments:

IPP Rev:A New Issue 07-09-24 EC verified by DD

12.10.24 PER DWG REV.B DD VERF:JLM

IPP REV:B

			· Litt is Litt										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Statu	ıs
M6061T6S.040		Purchased	No		100	sf	341.2200	0.1313	1.382105				
M6061T6	SS 040							**	1.362103			,	

m129584

M6061T6S 040

6061-T6 .040 Sheet

Location	Loc Oty	Loc Code	
MAT021	341.22		
m126350	22.52		
m126981	76.91		
m128422	49.79		
m129165	102		

WORK ORDER NON-CONFORMANCE / UPDATE OAC Closed: Date: Work Order update only Work Order: DISPOSITION	DQA:			Date:			- WORK ORDER MON CONFORMANCE / HRDATE						TRACE		
Work Order: Part No.							WORK ORDER NON-	-CC	ONFO	RMANCE / U				_	AEROSPACE
Part No. Scrap Use-as-is Suspected Unapproved Use-as-is Suspected Unapproved Use-as-is Use-as-is Suspected Unapproved Use-as-is	QA Closed:			Date:								Work Ord	ler up	odate only	
Part No.	Work Ord	or.					DISPOSITION				AGAINST I	DEPARTN	1ENT,	/PROCESS	
Part No.	WOIK OIG	٠					Rework	ı		Skid-tube	Crosstube			Water Jet 🗸	Engineering
NCR No. Use-as-is Suspected Unapproved Use-as-is Use-as-	Part	No.								}	-		Pro	 -	
Root Cause Date Step Qty Or non-conformance Chief Eng Description Design Doc/Data Equip/Tooling Handling/Fre Material Operator Offset/Setup Process Supplier Training Trainsport Unapproved Unapproved Unapproved Description of work order update Chief Eng Description Description Date Verification QC Inspector QC Inspector OC Inspector O		•					· 			·	F	Red		· · ·	⊣ '⊢ '
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Landing/Pre Landing/Pre Landing Pre Landing Pre Landing Gear Centre Not Concentric Cracks Image: Landing Gear Centre Not Concentric Cracks Image: Landing Gear Landing Gear Landing Gear Centre Not Concentric Cracks Image: Landing Gear Landing Gear Landing Gear Landing Gear Landing Cracks Image: Landing Gear Landing G	NCR	No.					Suspected Unapproved			Large Fab	Composite			Supplier	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Landing/Pre Landing/Pre Landing Pre Landing Pre Landing Gear Centre Not Concentric Cracks Image: Landing Gear Centre Not Concentric Cracks Image: Landing Gear Landing Gear Landing Gear Centre Not Concentric Cracks Image: Landing Gear Landing Landing Gear L	Poot					Desc	rintion of work order undate	一	nitial	Act	tion	Sign	&		
Design			Date	Step	Qtv	Desci	•							 Verification	QC Inspector
Doc/Data Equip/Tooling					,					-				****	
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Material	Equip/Tooling											ŀ			
Opfract/Setup Process Supplier Training Transport Unapproved Unapproved Bending Bend Folio/Program Outside Dimensions Pressure/Forced Grain Grain Part Incorrect Temperature/Cure Part Incorrect Temperature/Cure Temperature/Cu	Handling/Pre														
Offset/Setup Process Supplier Training Transport Unapproved Unappr	Material														
Process Supplier Training Transport Unapproved Unapprov	Operator														
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Training Trainsport Unapproved Tansport Unapproved Training Trai	Process														
Transport Unapproved	Supplier				<u> </u>										
Unapproved	Training	Ш													
FAULT CATEGORY Landing Gear General Bending Bend Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure	Transport	Ш													
Landing Gear Bending Centre Not Concentric Cracks General Folio/Program Outside Dimensions Over/Under tolerance Part Incorrect Temperature/Cure	Unapproved				<u> </u>			<u> </u>		<u> </u>					
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Cuffs Contamination Instructions Incomplete/Unclear Part Moved Wrong Stock Pulled		<u> </u>	1			<u> </u>		-	1		unciear	— i		_	vvrong Stock Pulled
Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other		-	•			\vdash		-	1	=		-			Other
		\vdash	ł		T., L -	\vdash		_	1		Ĺ		LU33/	Juige [Journal
Inspection Strip in Tube Drawing Misread		_	1		eauı	-	1	\vdash	1						
Turning Sequence Finish Out of Calibration		-	1			-	4	-	ł			-			····
		\vdash	Wave/Tw	•		-	Fit/Function	\vdash	4	Sequence					

DART AEROSPACE LTD	Work Order:	119562
Description: Bracket Front Plate	Part Number:	D3531-3
Inspection Dwg: D3531 Rev: B		Page 1 of 1

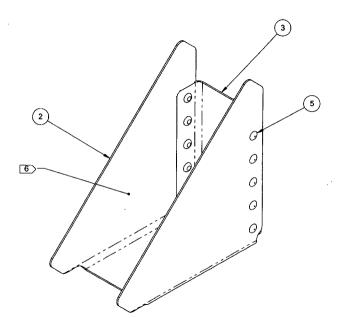
FIRST ARTICLE INSPECTION CHECKLIST

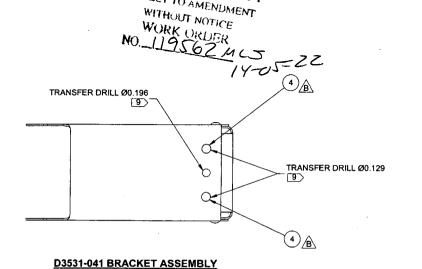
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	V		J'SKM-O	
3.72	+/-0.030	3.72				
0.37	+/-0.030	0:37				
2.840	+/-0.010	2.840				
0.88	+/-0.030	0.88				
3.50	+/-0.030	3.49				
4.67	+/-0.030	4.67				
	1					
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Measured	l by:	mm	Audited by:	27	2	Preliminary Approval:	
D	ate:	14/07/15	Date:	14/-9/	10	Date:	

Rev	Date	Change	Revised I	oy	Approved
Α	07.10.15	New Issue	KJ/EC/DD	10	
В	13.07.18	Dwg Rev updated	KJ <	*/	<u> </u>
				7 /	

ITEM NO. QTY.		PART NUMBER	DESCRIPTION	
1	х	D3531-041	BRACKET ASSEMBLY	
2	1	D3531-1	BRACKET	
3	1	D3531-3	BRACKET FRONT PLATE	
4	2	MS20426AD4-4	RIVET	ß
5	10	MS20470AD4-4	RIVET	





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D3531-041 BRACKET ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

4) ONLING BOTTO STORES OF THE TOTAL
7) WEIGHT: 0.22 lbs

8

8) ASSEMBLE PER DART QSI 003

9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3, ADD CSK, ZN C5-3, CORRECT BEND LINE DIM, ZN C4-3, UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47. DC 12.08.09 Α NEW ISSUE 07.06.19 CB REV. DESCRIPTION BY DATE DESIGN

DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3531 MFG. APPR. SHEET 1 OF 5 APPROVED TITLE SCALE BRACKET ASSEMBLY DE APPR. NTS DATE 12.08.09

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BOTTOM VIEW

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